

Date: Wednesday, 5/16/2007 1:45:25 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DART 4-MAN 3-POINT AFT FACING SHOULDER HARNESS ASSEMBLY	
Job Number	: 32421				
Estimate Number	: 12867				
P.O. Number	: N/A		Part Number	: D412702045B	
This Issue	: 5/16/2007	S.O. No. : N/A	Drawing Number	: D412702045B	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: D	
Previous Run	: 32331		Material	: N/A	
Written By	: <u>J. 07.05.16</u>		Due Date	: 5/23/2007	
Checked & Approved By	: <u>J. 07.05.16</u>		Qty:		
Comment	: est rev A 07.05.10 new issue EC		Um:	Each	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL

Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D412-702-045B CHG001

2.0 D412702111B HARNESS ASSEMBLY

Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
HARNESS ASSEMBLY *B32337*

3.0 D412702113B HARNESS ASSEMBLY

Comment: Qty : 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

HARNESS ASSEMBLY B37334 ✓

4.0 D3572041 GUIDE ASSEMBLY

Comment: Qty : 3,0000 Each(s)/Unit Total : 4,0000 Each(s)

GUIDE ASSEMBLY

50 AN416A Bolt

Comment: Qty.: 3.0000 Each(s)/Unit Total: 4.0000 Each(s)

Comments: Qty.. 2.0000 Each(S) Unit Total: 4.0000 Each(S)
Bolt

6.0 AN425A BOLT

Comment: Other - 4.0000 Each/Unit Total: - 8.0000 Each(s)

Commitment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 1:45:25 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DART 4-MAN 3-POINT AFT FACING SHOULDER HARNESS
ASSEMBLY

Job Number: 32421

Part Number: D412702045B

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0 AN960JD416

Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total: 40.0000 Each(s)

Washer

batch: M103691 X

8.0 MS21042L4

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total: 12.0000 Each(s)

Nut

batch: M102552 X

7/5/24 59

9.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7/5/24

7/5/24 ①

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-702-045B CHG001

Location: _____

PPP Rev: _____

Rev Draft 7/5/24 59

Job Completion



QC21 FINAL Inspection w/o release *7/5/24*

7/5/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041B	QTY -043B	QTY -045B	QTY -047B	QTY -049B	Part Number	Description	
X					D412-702-041B	Dart 13-Man 3-Point Shoulder Harness Kit	
	X				D412-702-043B	Dart 5-Man 3-Point Forward Facing Shoulder Harness Kit	
		X			D412-702-045B	Dart 4-Man 3-Point Aft Facing Shoulder Harness Kit	
			X		D412-702-047B	Dart 4-Man 3-Point Side Facing Shoulder Harness Kit	
				X	D412-702-049B	Dart 1-Man 3-Point Forward Shoulder Harness Kit	
1	1		1	1	D412-702-059	GROMMET KIT	
2	1		1		D412-702-101B	HARNESS ASSEMBLY	
1*	1*		1*		D3573-7	ADAPTER	
1*	1*		1*		D3579-046	SHOULDER HARNESS	
1*	1*		1*		K6.2	CLIP	
4*	4*		4*		MS24693S272	SCREW	
4*	4*		4*		AN960JD10LL	WASHER	
4*	4*		4*		MS21042L3	NUT	
1*	1*		1*		D3569-3	DECAL	
2	1		1		D412-702-103B	HARNESS ASSEMBLY	
1*	1*		1*		D3573-8	ADAPTER	
1*	1*		1*		D3579-045	SHOULDER HARNESS	
1*	1*		1*		K6.2	CLIP	
4*	4*		4*		MS24693S272	SCREW	
4*	4*		4*		AN960JD10LL	WASHER	
4*	4*		4*		MS21042L3	NUT	
1*	1*		1*		D3569-3	DECAL	
1	1			1	D412-702-105B	HARNESS ASSEMBLY	
1*	1*			1*	D3573-1	ADAPTER	
1*	1*			1*	D3579-046	SHOULDER HARNESS	
1*	1*			1*	K6.2	CLIP	
4*	4*			4*	MS24693S273	SCREW	
4*	4*			4*	AN960JD10LL	WASHER	
4*	4*			4*	MS21042L3	NUT	
1*	1*			1*	D3569-3	DECAL	
1	1				D412-702-107B	HARNESS ASSEMBLY	
1*	1*				D3573-3	ADAPTER	
1*	1*				D3579-046	SHOULDER HARNESS	
1*	1*				K6.2	CLIP	
4*	4*				MS24693S272	SCREW	
4*	4*				AN960JD10LL	WASHER	
4*	4*				MS21042L3	NUT	
1*	1*				D3569-3	DECAL	
1	1				D412-702-109B	HARNESS ASSEMBLY	SHOP COPY
1*	1*				D3573-3	ADAPTER	RETURN TO
1*	1*				D3579-045	SHOULDER HARNESS	ENGINEERING
1*	1*				K6.2	CLIP	UNCONTROLLED COPY
4*	4*				MS24693S272	SCREW	SUBJECT TO AMENDMENT
4*	4*				AN960JD10LL	WASHER	WITHOUT NOTICE
4*	4*				MS21042L3	NUT	WORK ORDER
1*	1*				D3569-3	DECAL	NO. 32421

• COPYRIGHT © 2003 BY DART AEROSPACE LTD. •
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: D
Date: 07.04.12

QTY -041B	QTY -043B	QTY -045B	QTY -047B	QTY -049B	Part Number	Description
2		2			D412-702-111B	HARNESS ASSEMBLY
1*		1*			D3570-1	BRACKET
1*		1*			D3579-047	SHOULDER HARNESS
4*		4*			MS24694S50	SCREW
4*		4*			AN960JD10L	WASHER
4*		4*			MS21042L3	NUT
1*		1*			D3569-3	DECAL
2		2			D412-702-113B	HARNESS ASSEMBLY
1*		1*			D3570-2	BRACKET
1*		1*			D3579-048	SHOULDER HARNESS
4*		4*			MS24694S50	SCREW
4*		4*			AN960JD10L	WASHER
4*		4*			MS21042L3	NUT
1*		1*			D3569-3	DECAL
1		1			D412-702-115B	HARNESS ASSEMBLY
1*		1*			D3573-5	ADAPTER
1*		1*			D3579-046	SHOULDER HARNESS
1*		1*			K6.2	CLIP
4*		4*			MS24693S272	SCREW
4*		4*			AN960JD10LL	WASHER
4*		4*			MS21042L3	NUT
1*		1*			D3569-3	DECAL
1		1			D412-702-117B	HARNESS ASSEMBLY
1*		1*			D3573-5	ADAPTER
1*		1*			D3579-045	SHOULDER HARNESS
1*		1*			K6.2	CLIP
4*		4*			MS24693S272	SCREW
4*		4*			AN960JD10LL	WASHER
4*		4*			MS21042L3	NUT
1*		1*			D3569-3	DECAL
2	2				D3542-1	BRACKET
7	3		4	1	D3571-1	GUIDE
2	2				D3571-3	GUIDE
2		2			D3572-041	GUIDE ASSEMBLY
12	6		6	2	D3578-041	DOUBLER
2	2				D3610-041	BRACKET
2	2				D3618-1	CAP
4	4				AN4-10A	BOLT
2		2			AN4-16A	BOLT
4		4			AN4-25A	BOLT
2	2				AN4-44A	BOLT
2	2				MS24693S274	SCREW
3	3			1	MS24694S56	SCREW
10	2		8		MS24694S58	SCREW
1	1			1	MS24694S60	SCREW
26	6	20			AN960JD416	WASHER
4	4				AN960JD416L	WASHER
12	6	6			MS21042L4	NUT
24	12		12	4	CR3212-4-4	RIVET

*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

SHOP COPY
RETURN TO

• COPYRIGHT © 2003 BY DART AEROSPACE LTD.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
Revision: D Date: 07/04/1120 UT NOTICE
NO. 32421
WORK ORDER

Date: Monday, 5/14/2007 7:15:02 AM.
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	HARNESS ASSEMBLY	
Job Number	32337		Part Number	D412702111B	
Estimate Number	12859		Drawing Number	ICA D412-702 P.79	
P.O. Number	N/A		Project Number	N/A	
This Issue	5/14/2007 S.O. No. N/A		Drawing Revision	D	
Prsht Rev.	NC		Material	N/A	
First Issue	N/A		Due Date	5/15/2007	
Previous Run	N/A		Qty:	10 Um: Each	
Written By			2		
Checked & Approved By	John, 05.14				
Comment	est rev A 07.05.11 new issue EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
---------	-----------------------	--------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



PTO

Comment: DOCUMENT CONTROL

type labels per PPP D412-702-111B CHG001
--

2.0	D35701	BRACKET
-----	--------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
--

BRACKET

batch: B31866

3.0	D3579047	SHOULDER HARNESS LH
-----	----------	---------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
--

SHOULDER HARNESS RH

batch: B32116

4.0	MS24694S50	Screw
-----	------------	-------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)
--

Screw

batch: M14206

5.0	AN960JD10L	Washer
-----	------------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)
--

Washer

batch: M101291

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/05/16	1	w/o split	ml	07/05/16	ml	2	07/05/24
07/05/24	8	Applied marine Adhesive sealant contact cement 07/05/24	ml	07/04	24		07/05/24

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 5/14/2007 7:15:02 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HARNESS ASSEMBLY

Job Number: 32337

Part Number: D412702111B

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 MS21042L3

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Nut

batch: M103641-20

M103641 20

7.0 D35693

DECAL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

DECAL

batch: 32086

mf 07/05/17

8.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



PTO

Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg ICA D412-702 p.79

SR 07/05/17
MF 07-05-23

9.0 QC5

INSPECT WORK TO CURRENT STEP



7/05/24 2

Comment: INSPECT WORK TO CURRENT STEP

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-702-111B CHG001

Location:

PPP Rev: Draft

6/10/24 2

QC 21 FINAL inspection No release

8/07/24

Job Completion



11/07/24

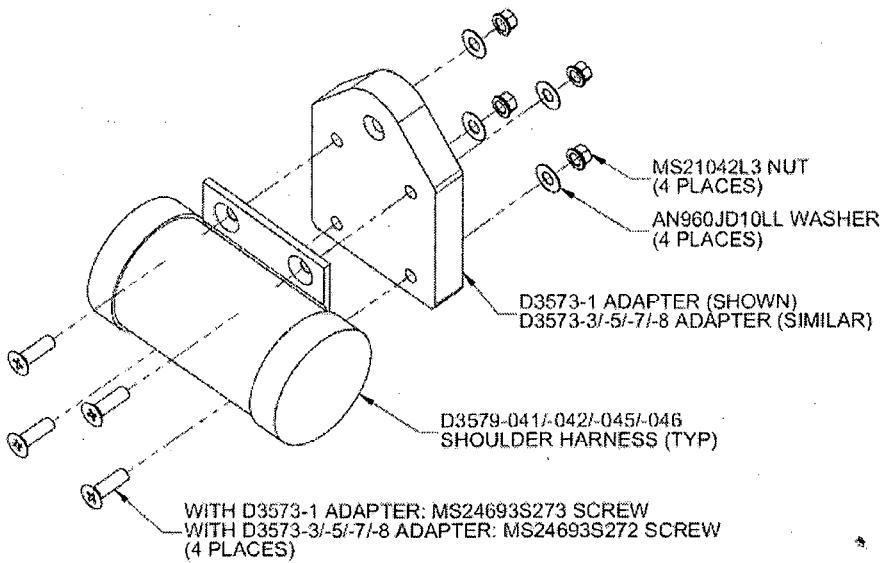
M103641

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

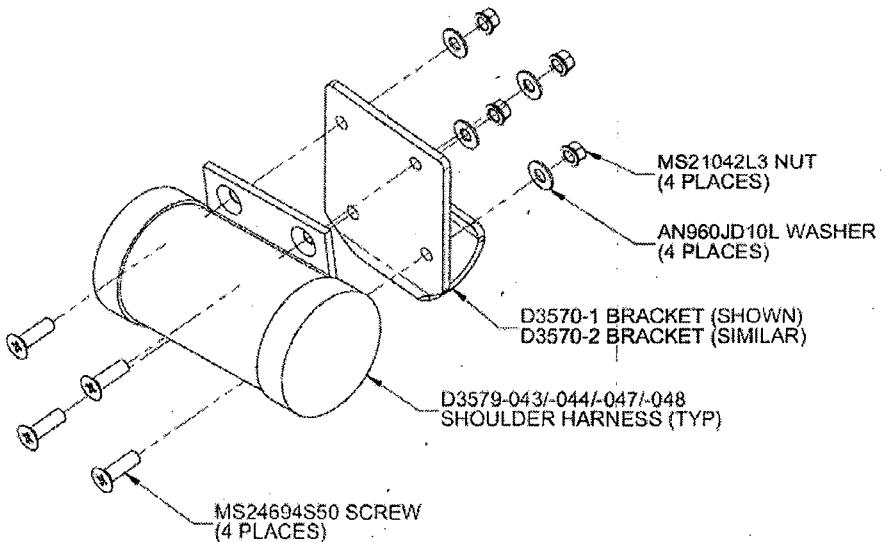
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/05/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/05/24	8.0	D3569-3 does not stick to the buckle, even with the recommended adhesive. 3M Fastcure 5200	<i>MS</i> 07/05/24	Apply a mid coat of contact cement to bond the label to the buckle.	SIB 07/05/24 M.1025CS	<i>MS</i> 07/05/24	<i>MS</i> 07/05/24	<i>MS</i> 07/05/24

NOTE: Date & initial all entries



DETAIL 'K' D412-702-101A/-103A/-105A/-107A/-109A/-115A/-117A AND
D412-702-101B/-103B/-105B/-107B/-109B/-115B/-117B HARNESS ASSEMBLIES
(BELTS, K6.2 CLIP AND D3569-1/-2/-3 DECAL NOT SHOWN)



DETAIL 'L' D412-702-111A/-111B/-113A/-113B HARNESS ASSEMBLIES
(BELTS AND D3569-1/-2/-3 DECALS NOT SHOWN)

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 32337

• COPYRIGHT © 2004 BY DART AEROSPACE LTD. •
 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR
 COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

25-00-00

Date: Monday, 5/14/2007 7:15:15 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	HARNESS ASSEMBLY	
Job Number	32338	Part Number	D412702113B	
Estimate Number	12860	Drawing Number	ICA D412-702 P.79	
P.O. Number	N/A	Project Number	N/A	
This Issue	5/14/2007	S.O. No.	N/A	
Prsht Rev.	NC	Type	SMALL /MED FAB	
First Issue	N/A	Material	N/A	
Previous Run		Due Date	5/15/2007	
Written By		Qty:	10	Um: Each
Checked & Approved By	98/07.05.14	<i>2</i>		
Comment	est rev A 07.05.11 new issue EC			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	DC	DOCUMENT CONTROL	<i>PTO</i>
2.0	D35702	BRACKET	
3.0	D3579048	SHOULDER HARNESS RH	
4.0	MS24694S50	Screw	
5.0	AN960JD10L	Washer	

Comment: DOCUMENT CONTROL
 type labels per PPP D412-702-113B CHG001

Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
 BRACKET
 batch: *B 31867* *✓*

Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
 SHOULDER HARNESS RH
 batch: *B 32117* *✓*

Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)
 Screw
 batch: *M 14206 -*

Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)
 Washer
 batch: *M 1-1291* *ml 07/05/17*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
ml 07/05/16	1	w/o split	ml	07/05/16	2	✓ 07/05/16	✓ 07/05/16
✓ 07/05/16	✓ 9	Applied Micro Adhesive Sealer m104524 contact cement m102565	DAE	✓ 07/05/16			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 5/14/2007 7:15:15 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HARNESS ASSEMBLY

Job Number: 32338

Part Number: D412702113B

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 MS21042L3

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Nut

batch: M104215 39X M103641-1X

7.0 D35693

DECAL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

DECAL

batch: B32086

✓ 07/05/17

8.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



PRO

Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg ICA D412-702 p.79

MF 07-05-23 ②

9.0 QC5

INSPECT WORK TO CURRENT STEP



0705-24②

Comment: INSPECT WORK TO CURRENT STEP

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-702-113B CHG001

Location:

PPP Rev: 001

045 07/05/24 ② ②

Job Completion

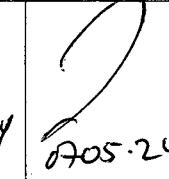
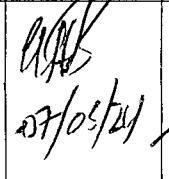


QC21 final inspection w/o release → 07/05/24

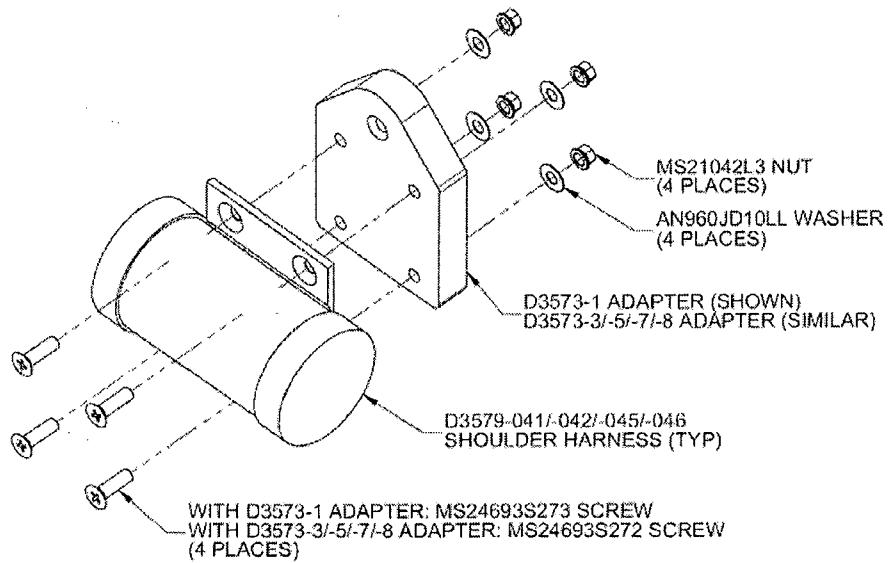
h 07/05/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

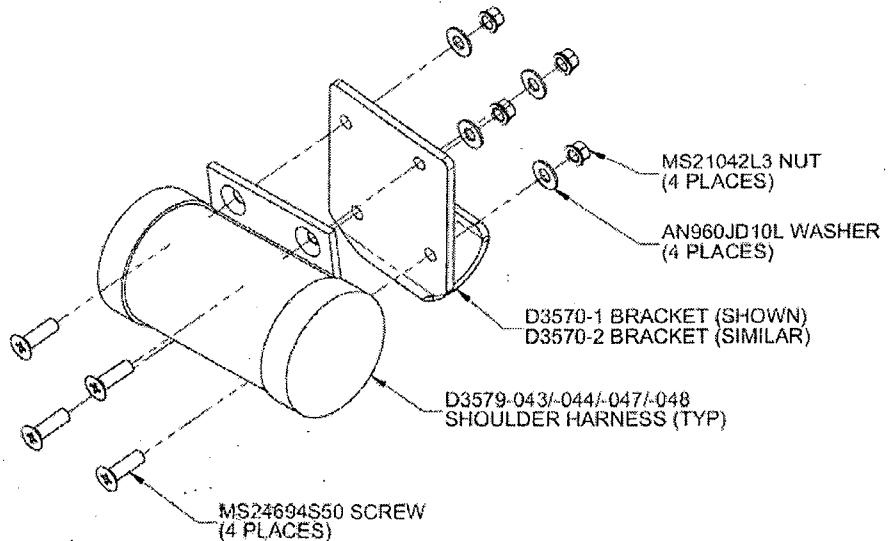
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/05/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/05/24	8.0	D3569-3 does not stick to the buckle, even with the recommended adhesive 3M Fast Cure 5200	 07/05/24	Apply a light coat of contact cement to bond the label to the buckle	SB 07/05/24 M 102 525	 07/05/24	 07/05/24	 07/05/24

NOTE: Date & initial all entries



DETAIL 'K' D412-702-101A/-103A/-105A/-107A/-109A/-115A/-117A AND
D412-702-101B/-103B/-105B/-107B/-109B/-115B/-117B HARNESS ASSEMBLIES
(BELTS, K6.2 CLIP AND D3569-1/-2/-3 DECAL NOT SHOWN)



DETAIL 'L' D412-702-111A/-111B/-113A/-113B HARNESS ASSEMBLIES SUBJECT TO AMENDMENT
(BELTS AND D3569-1/-2/-3 DECALS NOT SHOWN)

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 32328

• COPYRIGHT © 2004 BY DART AEROSPACE LTD. •
 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR
 COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

25-00-00